

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008264**Date Inspected:** 22-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia, Yu Dong Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly Area

This QA Inspector, George Goulet, randomly observed the following work in progress in the trial assembly area:

4AE, panel point 25 – ZPMC MT and occasional grinding, then MT again.

2AW, between panel points 13.5 and 14 – installation and snug tightening of DP splice bolt sets. Bolt sets were M22x2.5x65 and appeared to come from DGHM220021.

3AE, panel point 22, east side – removal of deck panel diaphragm to upper floor beam weld by gouging. ZPMC QC present was identified as CWI Li Jia (QC1). The gouging repair temperature requirement recorded by QC1 appeared to comply with the ZPMC repair order presented to this QA Inspector, George Goulet, by QC1 for this weld repair.

Bay 11

This QA Inspector, George Goulet, randomly observed the following work in progress in Bay 11:

SAW welding of weld joint WSD1-FDSA4-4A/D-6A, 7A located on south tower, lift 3. Welders was identified as 040772. ZPMC QC was identified as CWI Yu Dong Ping (QC2). The welding variables recorded by QC2

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appeared to comply with WPS-B-T-2221-B-U3c-S-2. Also present at this location and appearing to be monitoring the welding was ABF representative Zhang Xiong.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

This QA Inspector, George Goulet, asked each QC monitoring the welding if all the welding variables observed by QC appeared to comply with the appropriate WPS, including the preheat requirements according to thickness of the thickest member being welded. Each QC monitoring the welding showed this QA Inspector, George Goulet, that QC was carrying the proper temperature sticks to monitor the minimum and maximum preheat and interpass temperatures and replied that all QC observed did appear to comply.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
